

Date: Tuesday, 21/04/2009 4:00:56 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 47338		
Estimate Number	: 11162		
P.O. Number	:	Part Number	: D32641
This Issue	: 21/04/2009 S.O. No. :	Drawing Number	: D3264 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 43257	Material	:
Written By	:	Due Date	: 04/05/2009 Qty: 12 Um: Each
Checked & Approved By	: <u>Julie Dawson</u>		
Comment	: Est A04.09.02 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X04500	6061-T6 Bar 1.25 X 4.50
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Comment: Qty.: 0.5097 f(s)/Unit Total: 6.1160 f(s)
Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick
(M6061T6B1.250x04.500)
Identify for D3264-1
Batch: M111486

ml 09/04/25 (12)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blanks: 4.500" x 1.250" x 5.700" long Bar

ml 09/04/25 (12)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA447 and Dwg D3264
Identify as D3264-1
Deburr

H.A 09/04/25 (12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 09/04/25 (12)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ml 09/04/27 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BRACKET

Job Number: 47338

Part Number: D32641

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

umol BR

09/04/27

(112)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

m109996

START TIME:

13:05

OVEN TEMPERATURE:

320°

FINISH TIME:

13:35

umol BR

09/04/29

(x12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/04/29

(17)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location:

ST144

88

09/04/30

(x12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/30

Job Completion



mf 09-04-30

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DART AEROSPACE LTD		Work Order: 47338
Description: Bracket		Part Number: D3264-1
Inspection Dwg: D3264	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.687	✓			
0.063	+/-0.010	0.064	✓			
0.125	+/-0.010	0.125	✓			
0.875	+0.010/-0.020	0.880	✓			
0.062	+/-0.010	0.062	✓			
R0.03	+/-0.030	R0.03	✓			
R0.13	+/-0.030	R0.13	✓			
1.00	+/-0.030	1.007	✓			
0.125	+/-0.010	0.125	✓			
0.600	+/-0.010	0.601	✓			
4.000	+/-0.005	4.000	✓			
0.750	+/-0.010	0.751	✓			
Ø0.194	+0.005/-0.000	Ø0.196	✓			
5.50	+/-0.030	5.501	✓			
0.125	+/-0.010	0.128	✓			
0.063	+/-0.010	0.062	✓			
R0.25	+/-0.030	R0.25	✓			
4.27	+/-0.030	4.270	✓			
R0.30	+/-0.030	R0.30	✓			

Measured by: KA	Audited by: [Signature]	Prototype Approval: N/A
Date: 09/04/25	Date: 09/04/27	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	[Signature]

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

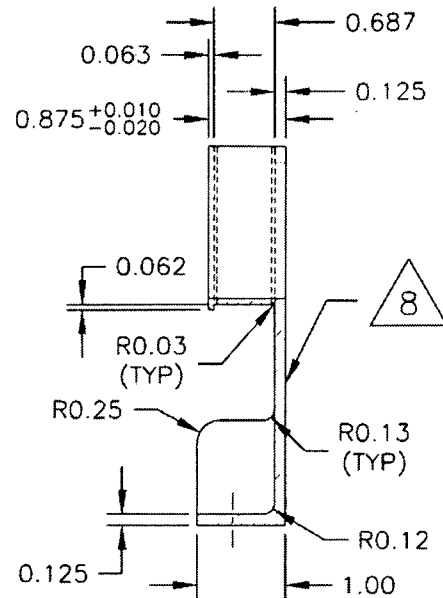
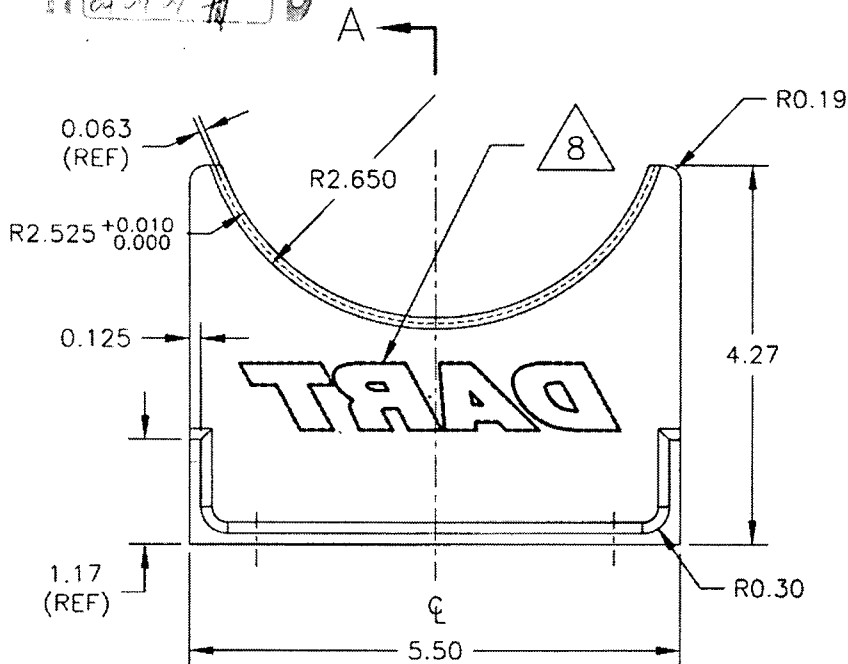
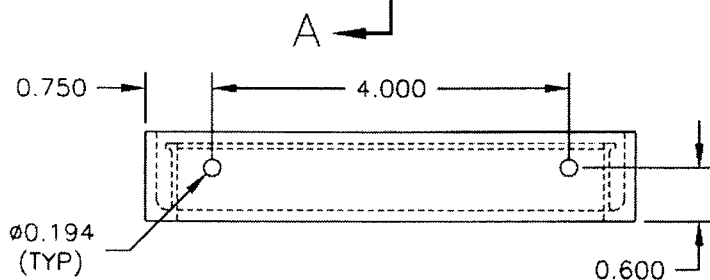
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NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED

**SECTION A-A****D3264-1 BRACKET****D3264-1:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. 4.1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41338

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